

Work Order ID 72186

Tuesday, July 19, 2011 2:42:55 PM



ASAP

Page 1

Item ID: D2525-5

Accept



Setup Start



Revision ID:

Item Name: Spacer

Stop



Start Date: 7/19/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/19/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: 11-07-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2525

Rev B

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

11/07/19

6

0

Hardinge CNC Lathe Small

1-Turn Blank as per Dwg D2525-2-Deburr

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

11/07/19

6

0

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

11/07/19

6

0

Quality Control

F

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72186

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Required Date: 7/19/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

6 BK 11-7-20

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11/7/2011 60

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

11/7/2011 60

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/2011

MF

11-07-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, July 19, 2011 2:42:49 PM

Page 1

Work Order ID: 72186

Parent Item: D2525-5

Parent Item Name: Spacer



Start Date: 7/19/2011

Required Date: 7/19/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP C C02.08.22 Make in Cobra KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	51.4830	0.0208	0.131368			



6061-T6 Round Bar .750"



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT013	51.483	
112442	0.796	
116406	0.617	
117481	26.07	
118106	24	

2 ~~720~~ 01/07/19

W/O:		WORK ORDER CHANGES					
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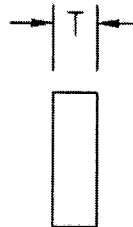
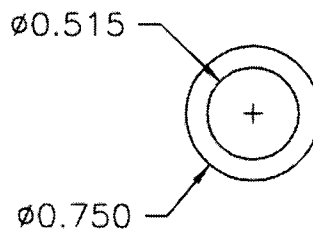
NOTE: Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED RF	DRAWING NO. D2525	REV. B SHEET 1 OF 1
DATE 99.09.30		TITLE SPACER KIT	SCALE 1:1
A	95.12.22	NEW ISSUE	
B	99.09.30	REVISED MATERIAL	

RELEASED
99.10.12 KE

PART NUMBER	THICKNESS T	QTY
D2525-1	0.750	1
D2525-3	0.250	1
D2525-5	0.125	4
D2525-7	0.063	0
D2525-9	0.032	0



#72186

#72186

MATERIAL: 5052-H32 (QQ-A-225/7) OR 1100 (QQ-A-225/1)
OR 6061-T6 (QQ-A-225/8) OR 6061-T6 (QQ-A-200/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

W/O:		WORK ORDER CHANGES					
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